

Date: Tuesday, 07/04/2009 10:18:29 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 46955			Part Number	: D2574	
Estimate Number	: 10534			Drawing Number	: D2574 REV E	
P.O. Number	:			Project Number	: N/A	
This Issue	07/04/2009	S.O. No.	:	Drawing Revision	: E	
Prsht Rev.	: NC			Material	:	
First Issue	: / /	Type	MACHINED PARTS	Due Date	24/04/2009	Qty: 10 Um: Each
Previous Run	: 45924					
Written By	:					
Checked & Approved By	: <u>JL 09.04.07</u>					
Comment	: Est Rev: I As Per RevE 06-01-27 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <u>46411</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>46955</u> Double check by: <u>mmw</u>	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2514 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 09/04/2022

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 46955		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/15	2.0	-1 part inside chamber of .06 is .095 R.C. chamber tool has the same offset for two different operations, offset was set for one operation but was too deep for 2nd operation * need different offsets for all operations	<input checked="" type="checkbox"/> JESMUR	Acceptable Acceptable see NCR on next page. Same part: same NCR.	JL 09/04/15	<input checked="" type="checkbox"/> 09/04/20	<input checked="" type="checkbox"/> JESMUR	<input checked="" type="checkbox"/> JESMUR
			<input checked="" type="checkbox"/> JESMUR				<input checked="" type="checkbox"/> JESMUR	<input checked="" type="checkbox"/> JESMUR

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:18:29 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 46955

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MF 09/04/20 10

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MF 09-04-20 10

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 11/09/39

START TIME: 1:00

OVEN TEMPERATURE: 320

FINISH TIME: 7:30

10

M 09-04-20

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MF 09/04/20 10

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5434

A 09/04/21

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22 MF

Job Completion



MF 09-04-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.04.16	2	CHAMFER ON BASE OF FLANGES IS 0.095" INSTEAD OF 0.063". ON (1) PART.	QP 09.04.16 pc QSI 042	Acceptable	BB 09/04/20	J	QP 09.04.16 pc QSI 042	/

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	410955
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					By	Date
				1	2	3	4			
A	0.438	0.443		.440	.438	.438	.440			
B	1.745	1.755		1.750	1.746	1.746	1.748			
C	3.495	3.505		3.500	3.500	3.500	3.500			
D	1.745	1.755		1.750	1.748	1.746	1.748			
E	7.990	8.010		7.999	8.003	8.003	8.003			
F	0.490	0.510		.499	.501	.498	.491			
G	0.257	0.262		.259	.258	.258	.258			
H	0.375	0.380		.376	.377	.377	.377			
I	0.490	0.510		.504	.502	.498	.502			
J	1.174	1.184		1.179	1.177	1.177	1.177			
K	0.558	0.578		.571	.564	.565	.566			
L	1.174	1.184		1.179	1.177	1.177	1.177			
M	1.365	1.375		1.370	1.368	1.370	1.370			
N	2.495	2.505		2.500	2.501	2.500	2.500			
O	4.119	4.129		4.124	4.123	4.124	4.124			
P	0.115	0.135		.124	.126	.124	.124			
Q	0.115	0.135		.135	.135	.135	.135			
R	0.240	0.260		.249	.253	.254	.254			
S	0.115	0.135		.126	.126	.128	.128			
T	0.178	0.198		.188	.188	.188	.188			
U	3.210	3.250		3.230	3.225	3.226	3.227			
V	0.230	0.250		.238	.240	.240	.240			
W	0.115	0.135		.128	.128	.129	.133			
X	0.307	0.312		.310	.310	.311	.311			
Y	0.760	0.765		.760	.760	.760	.760			
Z	0.352	0.372		.364	.361	.363	.361			
AA	0.470	0.530		.500	.500	.500	.500			
AB	0.615	0.635		.626	.627	.626	.627			
AC	0.053	0.073		.063	.063	.063	.063			
AD	0.240	0.260		.243	.248	.251	.253			
AE	1.500	1.520		1.515	1.515	1.515	1.515			
AF	0.115	0.135		.135	.135	.135	.135			
AG	0.240	0.280		.260	.220	.270	.280			
AH	0.240	0.260		.247	.249	.249	.250			
AI	2.000	2.020		2.005	2.005	2.005	2.003			
AJ	0.023	0.043		.033	.033	.023	.023			
Accept/Reject										

Measured by:	JL
Date:	09/04/14

Audited by:	87
Date:	09/04/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JK JLM

DART AEROSPACE LTD	Work Order:	46955
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1 5	2 6	3 7	4 8		
A	0.438	0.443		.438	.438	.439	.440		
B	1.745	1.755		1.748	1.748	1.748	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.747	1.748	1.750		
E	7.990	8.010		8.003	8.003	8.005	8.001		
F	0.490	0.510		.510	.505	.490	.499		
G	0.257	0.262		.258	.258	.258	.260		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.500	.501	.501		
J	1.174	1.184		1.178	1.179	1.178	1.178		
K	0.558	0.578		.571	.569	.569	.569		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.365	1.375		1.368	1.369	1.369	1.370		
N	2.495	2.505		2.494	2.500	2.500	2.500		
O	4.119	4.129		4.123	4.122	4.121	4.125		
P	0.115	0.135		.125	.124	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.253	.254		
S	0.115	0.135		.121	.129	.131	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.225	3.225	3.228	3.226		
V	0.230	0.250		.238	.239	.241	.240		
W	0.115	0.135		.124	.127	.127	.126		
X	0.307	0.312		.311	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.361	.363	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.625	.625	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.514	1.516	1.517	1.516		
AF	0.115	0.135		.125	.135	.116	.135		
AG	0.240	0.280		.280	.280	.280	.276		
AH	0.240	0.260		.267	.266	.265	.269		
AI	2.000	2.020		2.001	2.000	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	/ JL
Date:	09/04/18

Audited by:	/
Date:	09/04/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	146955
Description: Saddle, Aft Inboard	Part Number:	D2574
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				1	2	3	4		
A	0.438	0.443		.440	.440				
B	.1745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		7.998	8.000				
F	0.490	0.510		.500	.500				
G	0.257	0.262		.258	.259				
H	0.375	0.380		.377	.376				
I	0.490	0.510		.503	.503				
J	1.174	1.184		1.178	1.179				
K	0.558	0.578		.569	.572				
L	1.174	1.184		1.178	1.179				
M	1.365	1.375		1.369	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.122	4.124				
P	0.115	0.135		.125	.125				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.253	.251				
S	0.115	0.135		.127	.126				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.226	3.230				
V	0.230	0.250		.239	.239				
W	0.115	0.135		.126	.127				
X	0.307	0.312		.310	.310				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.363	.363				
AA	0.470	0.530		.506	.500				
AB	0.615	0.635		.627	.628				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.245	.245				
AE	1.500	1.520		1.517	1.516				
AF	0.115	0.135		.120	.135				
AG	0.240	0.280		.280	.260				
AH	0.240	0.260		.249	.246				
AI	2.000	2.020		2.001	2.004				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	/ J.L.	Audited by:	8P/
Date:	09/04/18	Date:	09/04/20

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